

Work Order ID **77462**

Thursday, December 08, 2011 6:22:01 AM

77462

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Item ID: D3859-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 12/8/2011 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *1-12-08*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3859 Dwg Rev: *A* Prog Rev: *A* 2-
Deburr if necessary*364.063**B11-12-8**(9)*

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-12-8

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8/11/2008**(7)*

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Item ID: D3859-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 12/8/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Large Fab					X5	1BL	12-02-01	
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009.3 cups as per dwg D3859 A/R 316L stainless steel rod Batch: <u>M114509</u> 2-Weld hard facing as per Dwg D3859 A/R 2059B Hard Coat rod Batch: <u>M120165</u> *****use DT9462 for welding*****								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140						X5	Ø		
QC	Memo	0.00							
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

S 12/02/02
 BS 77462

77462

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powdercoat

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME: _____

170

QC3- Inspect Part Finish

0.00

Memo

0.00

OC

Quality Control

180

Identify as per dwg & Stock Location: 0.00

0.00

Memo

0.00

Packaging

Packaging

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Revision ID: Stop ***NS2***
Item Name: Wearplate
Start Date: 12/8/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/12/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/24

WMS 12-02-24

Picklist Print

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Work Order ID: 77462

Parent Item: D3859-041

Parent Item Name: Wearplate

Start Date: 12/8/2011

Required Date: 12/12/2011

Start Qty: 2.00

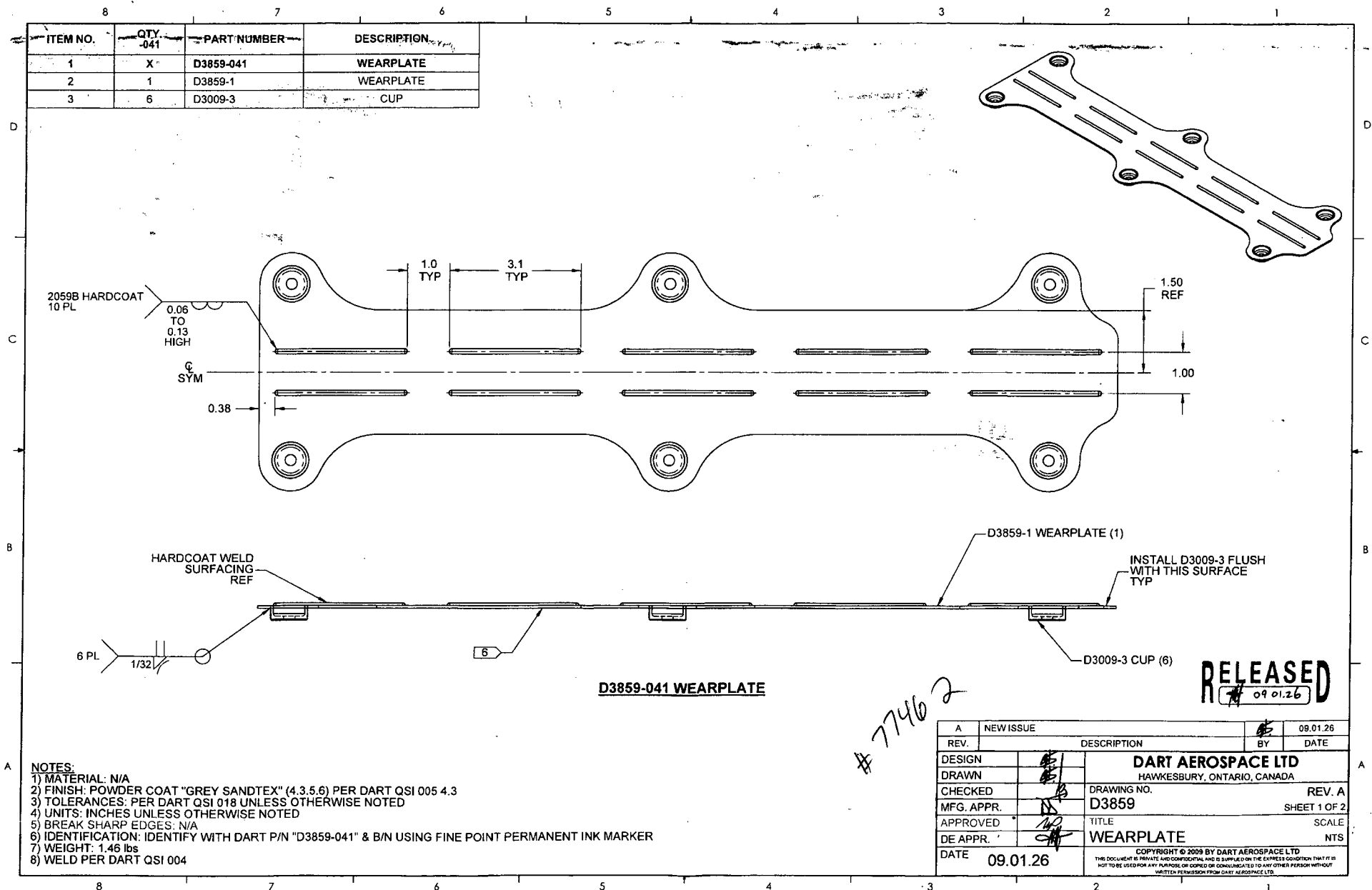
Required Qty: 2.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	237.6000	0.85	1.7	1.7	12-12-8	✓
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT020		237.6							
				119653		237.6							
D3009-3 Cup		Manufactured	No			130	Each	39.0000	6	12			④
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA030		39							
				73699		39							

1 missing
end of stock

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP



REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.01.26			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D3859	SHEET 1 OF 2
TITLE WEARPLATE	SCALE NTS

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